DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-003704

Address: 333 Burma Road **Date Inspected:** 22-Aug-2008

City: Oakland, CA 94607

OSM Arrival Time: 1330 **Project Name:** SAS Superstructure **OSM Departure Time:** 2230 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: See below **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:**

Bridge No: 34-0006 **Component: OBG** Fabrication

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Orthotropic Box Girder (OBG):

Bay #1

QA witnessed ZPMC UT Inspector Mr. Xu Ronggang performing ultrasonic inspection of deck plate DP254-001 U rib splice welds 190, 191, 192, 193 and 194 and items observed appear to comply with project specifications.

QA performed AWS D1.5 ultrasonic inspection of deck plate DP254-001 U rib splice welds 192 and 194 and items observed appear to comply with project specifications. See the photograph below and the TL6027 ultrasonic test report for additional information.

OBG Assembly Bay 2

The QA Inspector recorded data for conventional and phased array ultrasonic inspections of deck panels DP042-001, DP044-001 and DP063-001. These three deck panels had been ultrasonically inspected by other QA Inspectors and this information will be submitted to Engineering for review.

WELDING INSPECTION REPORT

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Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer